

Work Order ID 83255

April-16-12 1:33:32 PM

ASAP

83255

Page 1

Item ID: D3537-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearpad

Stop *NS2*

Start Date: 16/04/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: M L J

Date: 12/04/16 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3537

Rev C

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr if necessary

1812-4-18

SC

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1812-4-19

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/26/12

counts
ASO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Solder

cup

φ

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

170

Powdercoat

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

0.00

0.00

0.00

0.00

M117338

3200F

2530
3500

SOX φ *m-l* *12/04/05*

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

50 φ *BDH-25*

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: *EP-2*

0.00

190

Packaging

Memo

0.00

Packaging

50 0 124-25 ☺

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/4/26

12-04-26

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Picklist Print

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Page 1

Work Order ID: 83255

83255

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 16/04/2012

Required Date: 23/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	234.1520	0.106	5.578947			

M304S16GA

**

BCL-4-18

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

234.152

120866

38.446

120877

137.326

121070

58.38

121070

59

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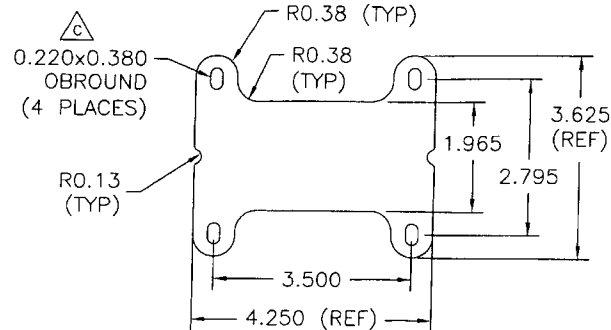
SHOP COPY

RETURN TO
ENGINEERING

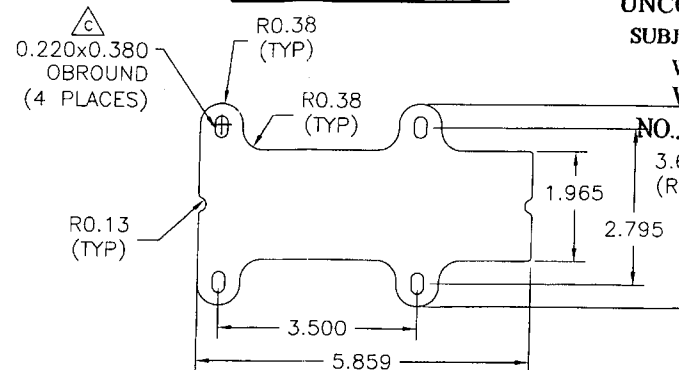
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83255 MLJ
12/04/10

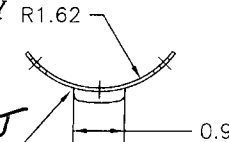
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN



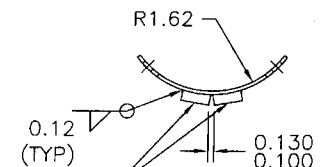
SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

OK 11/11/15

SECTION B-B



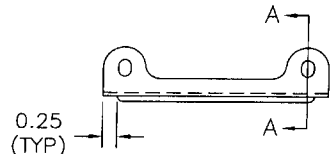
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

UNDER REVIEW
11/11/15
Change

RELEASED
07.05.03 AH
REV EGN

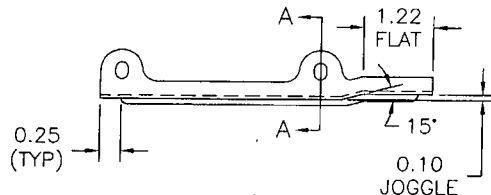
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



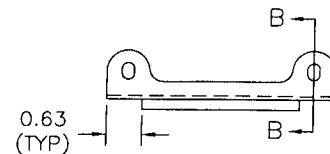
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)



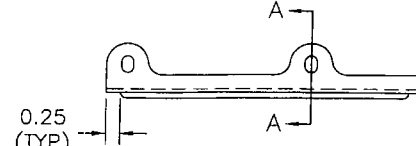
D3537-5 LONGITUDINAL BEND

(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY
CHECKED	#	APPROVED
DATE	07.04.13	TITLE
		WEARPAD
		DART AEROSPACE USA, INC. PORT HADLOCK, MA
		DRAWING NO. D3537
		REV. C SHEET 1 OF 1
		SCALE 1:2

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